

# Work Order ID 88136

\*88136\*

Page 1

July-27-12 10:01:24 AM

Item ID: D3913-9

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Hinge Rib

Start Date: 27/07/2012 Start Qty: 3.00

\*3\*

(4X)

Cust Item ID:

Required Date: 16/08/2012 Req'd Qty: 3.00

\*3\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: MLJ

Date: 12/07/27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3913

AB

100

0.00

\*100\*

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D3913  
2- remove identification marks and deburr

(4X)

CC 12-11-21

110

QC6- Inspect dimensions to drawing

0.00

\*110\*

QC

Memo

0.00

Quality Control

(4)

12-11-21

DAS  
09  
88

120

Identify as per dwg & Stock Location: W/A

0.00

\*120\*

Packaging

Memo

0.00

Packaging

(4X)

CC 12-11-21

**Work Order ID 88136****\*88136\***

Page 2

July-27-12 10:01:24 AM

Item ID: D3913-9

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Hinge Rib

Start Date: 27/07/2012 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 16/08/2012 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/11/22 dg  
mf  
12-11-22

# Picklist Print

July-27-12 10:01:29 AM

Page 1

Work Order ID: 88136

\*88136\*

Parent Item: D3913-9

\*D3913-9\*

Parent Item Name: Hinge Rib

Start Date: 27/07/2012

Required Date: 16/08/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased			No	100	f	322.4533	7.875	24.86842			

\*M304TS0 750W 049\*

304 SQ Tube .75x.75x.049W

\*\*

CC 12-11-21

## Location

MAT017  
121898  
MAT018  
119147  
119643  
121439  
122201  
122425  
WA034  
121087

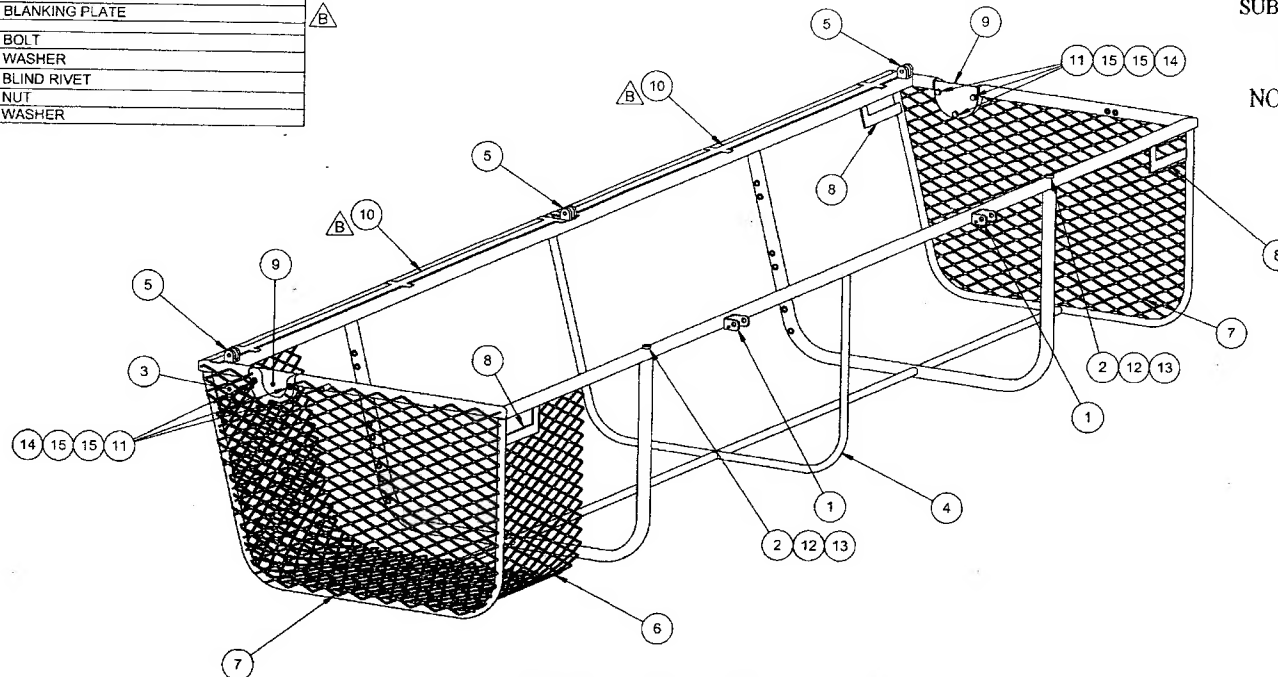
## Loc Qty

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1.0078107  
320.3829959  
2  
3.30639585  
12.45  
2.6266  
300  
1.0625  
1.0625

## Loc Code

M123484 → 33.157893

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	BLIND RIVET
14	6	MS21042L3	NUT
15	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

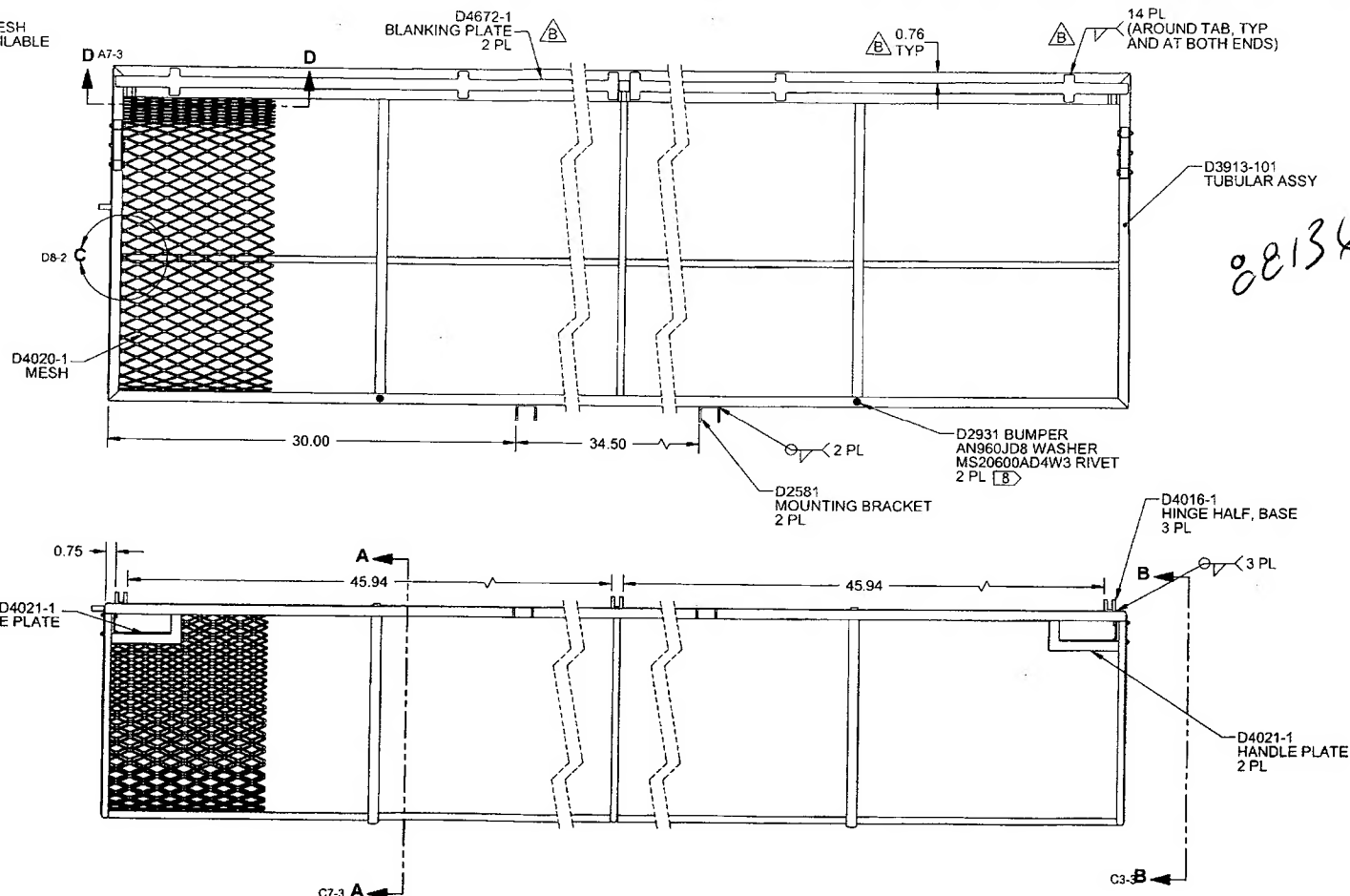
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2012-07-12  
ECN 12-64

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 88136 MCT  
12/07/27

B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PART12-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	D3913	SHEET 1 OF 6
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	LONG BASKET BASE ASSY (350) NTS	
DE APPR.	<i>[Signature]</i>	DATE 12.06.15	
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TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

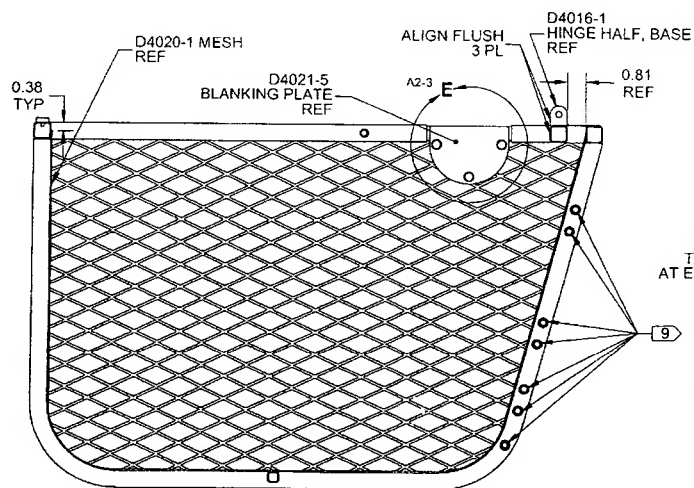
**DETAIL C** D7-2



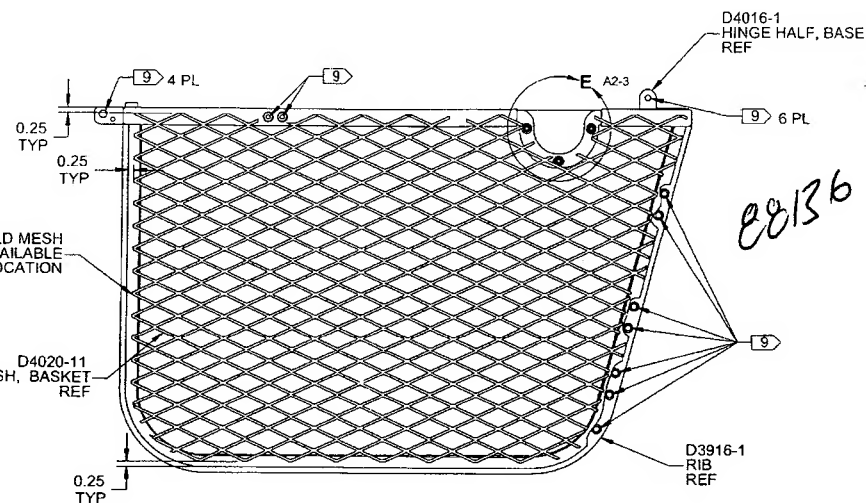
**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

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2012-07-12  
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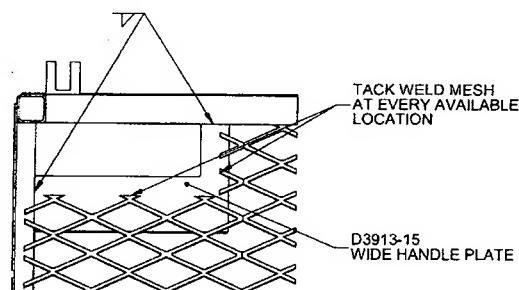
DESIGN	ALS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. B
DRAWN			SHEET 2 OF 6
CHECKED	A.P.		SCALE
MFG. APPR.			TITLE
APPROVED	<i>[Signature]</i>		LONG BASKET BASE ASSY (350) NTS
DE APPR.	<i>[Signature]</i>		
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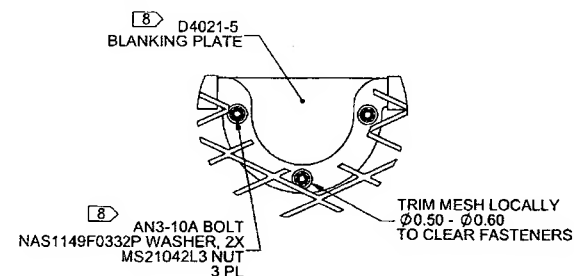
**SECTION A-A** A5-2



**VIEW B-B** A2-2



**SECTION D-D** D6-2  
TYPICAL FOR ALL  
HANDLE PLATES

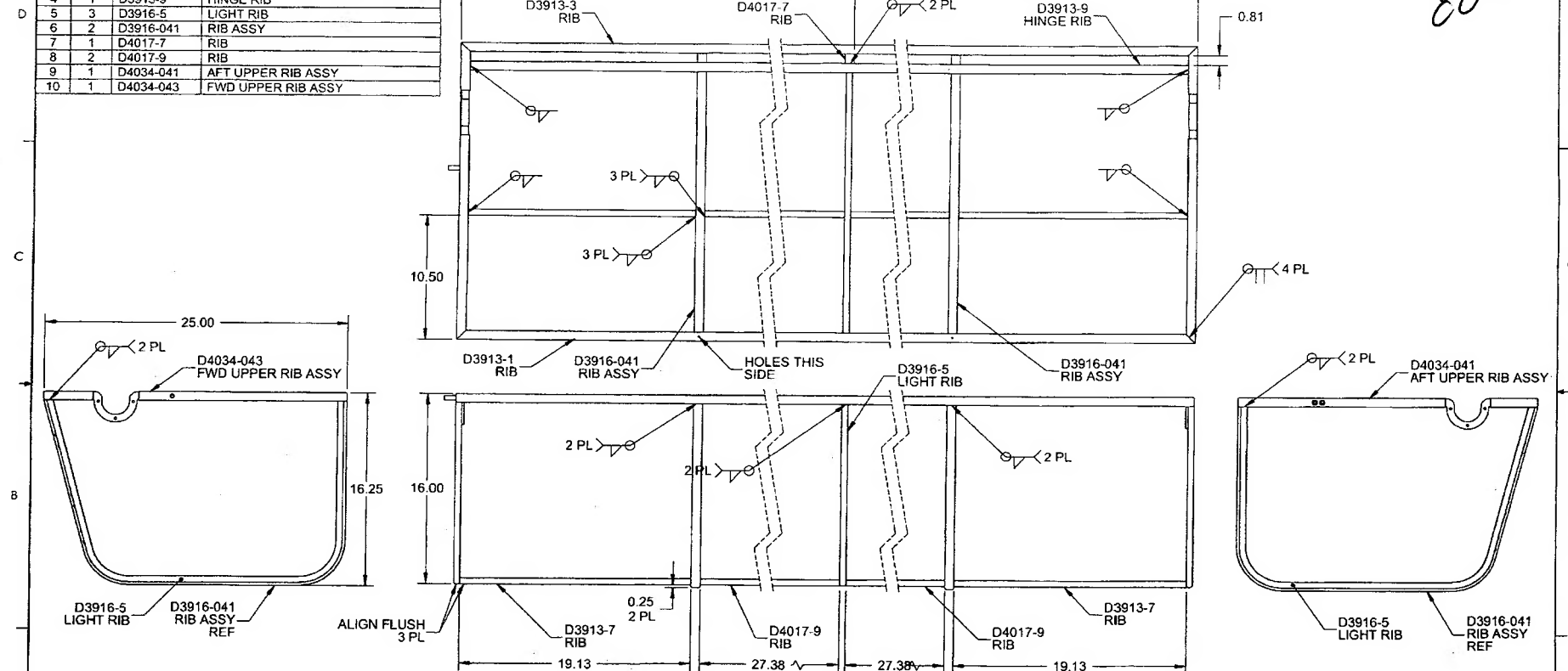


**DETAIL E** D2-3  
D6-3

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4P

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DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	ALS	D3913	SHEET 3 OF 6
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	<b>LONG BASKET BASE ASSY (350) NTS</b>	
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



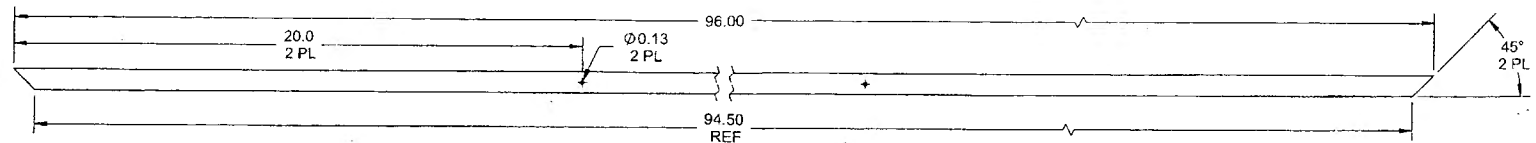
8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

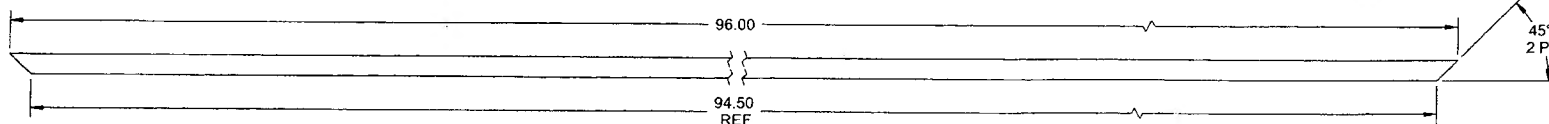
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2012-07-12  
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CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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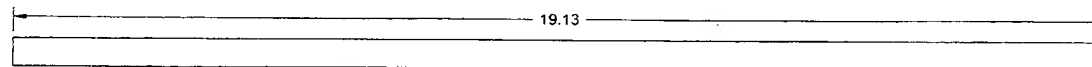


**D3913-1 RIB**

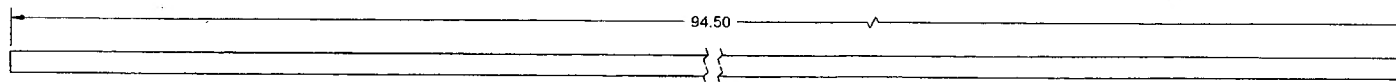
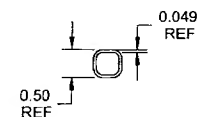
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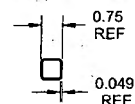
**D3913-3 RIB**



**D3913-7 RIB**



**D3913-9 HINGE RIB**



**NOTES:**

1) MATERIAL -1, -3, -9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
PER ASTM A554 OR ASTM A269 MILL FINISH  
REF DART SPEC. M304TS0.750W.049

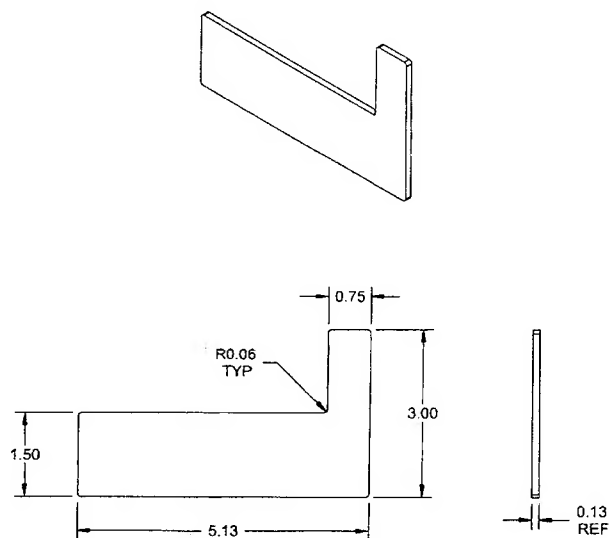
-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
PER ASTM A554 OR ASTM A269 MILL FINISH  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

**RELEASED**  
2012-07-12  
CP

DESIGN	AS	<b>DART AEROSPACE LTD</b>	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.V.	DRAWING NO.	REV. B
MFG. APPR.	MP	D3913	SHEET 6 OF 6
APPROVED	MP	TITLE	SCALE
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